

Desen 54745

Work Order ID 53043

October 22, 2009 11:25:53 AM



Item ID: D3813-041
Revision ID: A
Item Name: Hinge Assembly, Upper Door
Start Date: 21/10/2009 Start Qty: 5.00
Required Date: 30/10/2009 Req'd Qty: 5.00
Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3813	Rev A								
100	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Install helicoils as per Dwg D3813 2-Install Ball joint and nut loosely as per Dwg D3813								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									

5X

7 m.d. 08/12/16

27 50 12/17

5

9/12/17 5 SP

Work Order ID 53043

October 22, 2009 11:25:53 AM



Page 2

Item ID: D3813-041
Revision ID: A
Item Name: Hinge Assembly, Upper Door

Accept



Setup Start



Stop



Start Date: 21/10/2009 Start Qty: 5.00

Required Date: 30/10/2009 Req'd Qty: 5.00



Cust Item ID:

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/18 JH

RL 09-12-18
(5)

Picklist Print

October 22, 2009 11:25:57 AM

Page 1

Work Order ID: 53043

Parent Item: D3813-041RevA

Parent Item Name: Hinge Assembly, Upper Door

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3518-3RevB

Manufactured

No

100

Each

18.0000

5.0000



Stainless Steel Ball Joint Rod End

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48211

Main Warehouse

ST109

51108

52270

3

3

15

5

10

100

Each

15.0000

5.0000

D3813-1RevA

Manufactured

No



Hinge, Upper Door

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45795

52288

15

5

10

100

Each

8.0000

5.0000

MS124738

Purchased

No



Heli-Coil 3/8-24 unf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

109249

8

8

~~M113288~~

M113368

5x

m-l out/12/16

5x

m-l out/12/16

5x

m-l out/12

Picklist Print

Page 2

October 22, 2009 11:25:58 AM

Work Order ID: 53043



Parent Item: D3813-041RevA



Parent Item Name: Hinge Assembly, Upper Door



Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS509-6  Nut		Purchased	No			100	Each	18.0000	5.0000 			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

109249

8

112492

10

M 113 147

SX m-l 09/12/16

X

October 22, 2009 11:25:58 AM

Shop Packet Print

Page 2

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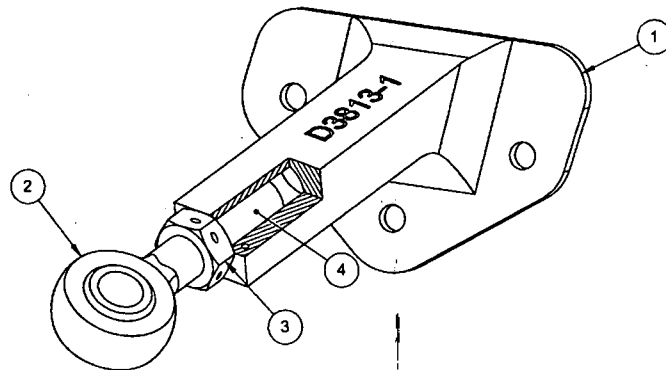
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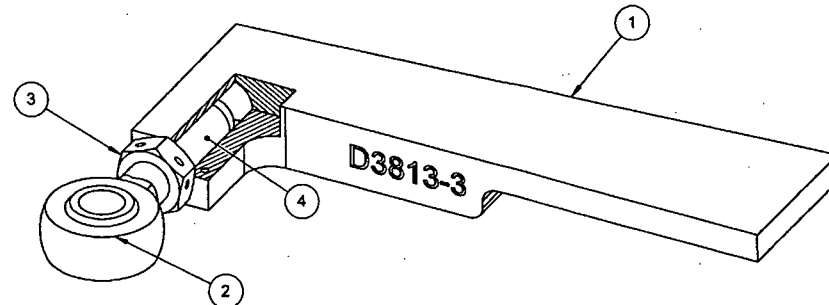
NO. 53043

BL 09-10-22



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3813-1	HINGE, UPPER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

D3813-041 HINGE ASSY, UPPER DOOR



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -043
1	D3813-3	HINGE, LOWER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

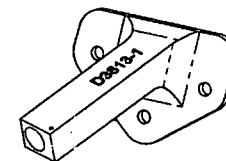
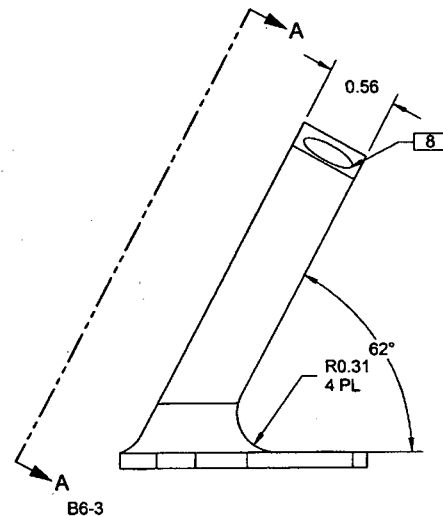
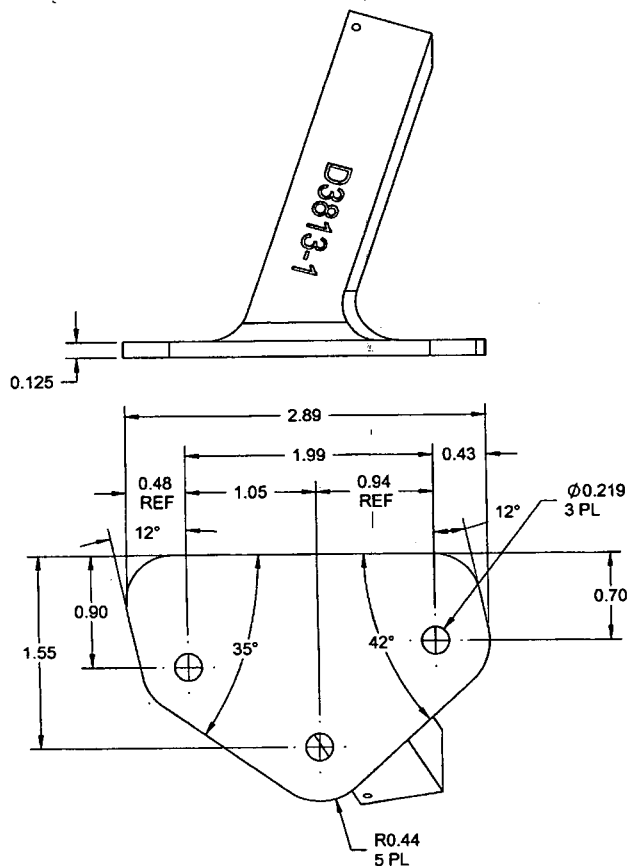
D3813-043 HINGE ASSY, LOWER DOOR

RELEASED
09/01/13

A	NEW ISSUE	BY	08.11.10
REV.	DESCRIPTION	DATE	
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3813	REV. A
TITLE HINGE	SHEET 1 OF 4
	SCALE NTS

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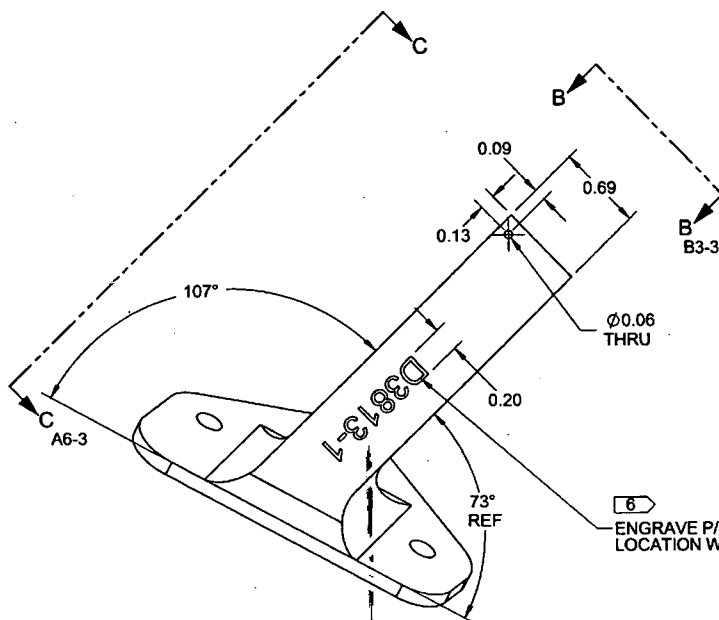
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09/01/12

D3813-1 HINGE, UPPER DOOR

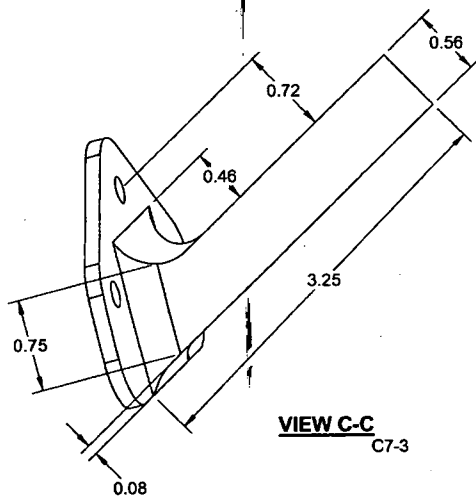
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.14 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

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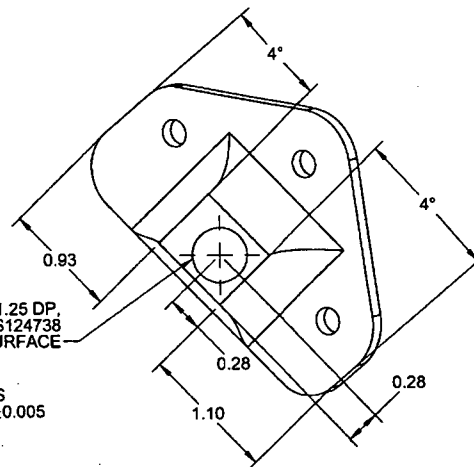
VIEW A-A
C4-2



VIEW C-C
C7-3

Ø0.391 X 1.25 DP,
INSTALL HELICOIL MS124738
FLUSH WITH SURFACE

ENGRAVE P/N TO DEPTH OF 0.005 IN THIS
LOCATION WITH TOOL TIP RAD OF 0.015±0.005






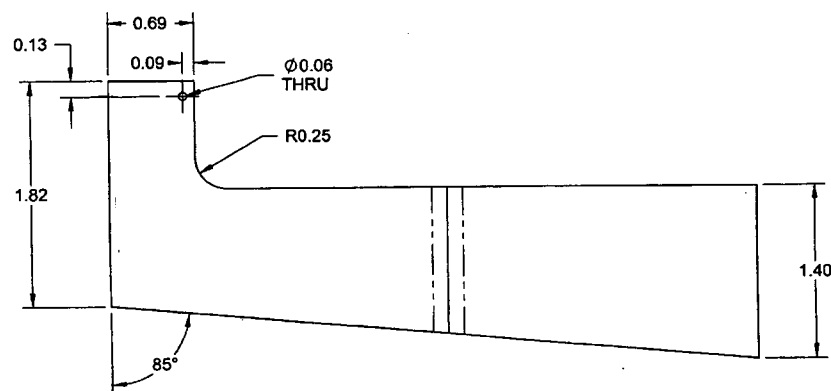
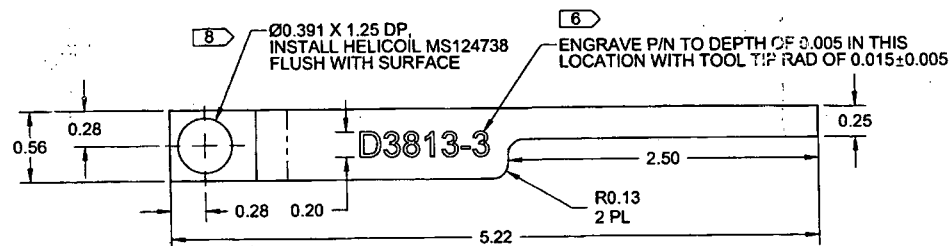
VIEW B-B
D5-3

D3813-1 HINGE, UPPER DOOR

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NO. 53043

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09/01/13

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D3813-3 HINGE, LOWER DOOR



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WORK ORDER
NO. 5304-3

RELEASED
07/07/12 MDP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.24 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

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